

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002627**Date Inspected:** 07-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen chi Ming (03110711)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Side Plates & Bottom Plates & Floor Beam C**Summary of Items Observed:**

The Quality Assurance (QA) Inspector,Mahlon Lindenmuth,arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following:

QA Inspector, Lindenmuth, observed the work being performed in Bay 2 of the New OBG. ZPMC personnel were performing various functions related to the fabrication of the OBG Side Plates and Bottom Plates as well as the deck sections in the jig fixture. The fabrication observed included but was not limited to the preparation of areas where temporary welds for strongbacks are located, bevel preparation and welding of the Complete Joint Penetration welds (CJP)on Side Plates and Bottom Plates,heat straightening of Side Plates and Bottom Plates.

Member identification and the work performed on the member are as follows:

Segment 3AE (Side plate): Heat straightening of the member was performed by placing (2)four ton weights on both sides of the CJP weld splice, joining SP29A to SP21A. The heat straightening was performed using an approved procedure and was monitored by ZPMC Quality Control personnel.

SEG017A-002: Caltrans QA observed ZPMC personnel performing base metal repairs on SEG017A. The areas of base metal repairs are located in areas where the temporary welds, securing the strongbacks to the side plates, have been removed. The welding variables are noted below.

SEG020A-002: Caltrans QA observed ZPMC personnel performing the grinding preparation of the CJP weld

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joining SP24A to SP32A.

OBG Jig Fixture (South): Caltrans QA did not observe ZPMC personnel performing any work on Segment 3BE(SEG16) today.

| Item | Weld Identification | Applicable WPS | CWI Name | Amperage | Voltage | TravelSpeed | Preheat Temp | Remarks |
|------|---------------------|--------------------------------|----------|----------|---------|-------------|--------------|---------|
| 1 | SEG017A-002 | WPS-345-SMAW-1C (E-61M) Repair | CLH-HIMB | 175 | 23 | 220mm/m | 160 C | |

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| Inspected By: | Lindenmuth,Mahlon | Quality Assurance Inspector |
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| Reviewed By: | Cuellar,Robert | QA Reviewer |
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